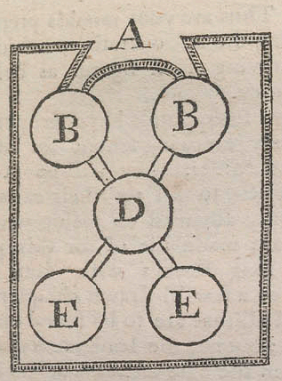
The depth of your mould muſt be determined by the thickneſs of your intended dump; and here, as I before adviſed you to make it the ſize of a half-penny, ſo would I adviſe you to make it of the ſame thickneſs. For this purpoſe, you may put a half penny into the dye, and, when it is perfectly even with the ſurrounding ſides, you will then be certain that you have ſcraped to a ſufficient depth. If the half-penny ſticks up in any particular part, take it out, and ſcrape away the obſtacle; for, the beauty of your caſt depends much on its roundneſs and equality of thickneſs.

Having made the bottom of each dye perfectly ſmooth and level, then cut the proper channels for the metal to paſs through the mould from one dump to another. The annexed repreſentation may perhaps make this matter appear more clear than from words only.

Cut



Cut a deep and wide notch in the mould at A; from this carry two little gutters, to convey the hot metal into the two caſts B B. From each of theſe cut another channel, to convey the metal into the center caſt D; and obſerve the ſame method for E E. Theſe groves or channels ſhould be rather deep than wide, as the metal will thereby have leſs time to cool before it arrives at the laſt

 dyes,